

Work Order ID 66247

February 8, 2011 10:05:22 AM



Page 1

Item ID: D3278-1

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 2/08/11 Start Qty: 40.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: C.L.

Date: 11/02/08

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3278	Rev C	

100



BAND SAW

0.00

H.A 11/03/08

40 0

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank: 2.00" x 1.00" x 2.550" long

110



HAAS CNC VERTICAL MACHINING #1

0.00

H.A 11/03/09

40 0

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1- Machine as per Folio FA405 and Dwg D3278-2- Deburr and
Tumble Identify as D3278-1

120



QC2- Inspect parts off machine FAI/FAIB

0.00

H.A 11/03/09

40 0

QC

Memo

0.00

Quality Control



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66247

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Page 2

Item ID: D3278-1

Accept



Setup Start



Revision ID:

Item Name: Support

Stop



Start Date: 2/08/11 Start Qty: 40.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC8- Inspect parts - second check

0.00

CRK 11-03-10

40 0



QC

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

AE 11-03-11 (40)

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Powder Coating

Memo

0.00

START TIME:

8:55

OVEN TEMPERATURE:

FINISH TIME:

8:55

H6 BL 11-3-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66247

February 8, 2011 10:05:22 AM



Page 3

Item ID: D3278-1

Accept



Setup

Start



Revision ID:

Item Name: Support

Stop



Start Date: 2/08/11 Start Qty: 40.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Packaging

Packaging

Identify as per dwg & Stock Location SMALL flat 0.00

Memo

0.00

counts

11/3/15

40

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

CL110315

11/3/15 JJ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 8, 2011 10:05:22 AM

Page 1

Work Order ID: 66247



Parent Item: D3278-1



Parent Item Name: Support

Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A 04.04.19 New issue KJ/JLM
IPP B 07.09.06 rev.c dwg EC verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	53.4303	0.2337	9.84			

6061-T6 Bar 1.00 x 2.00



Location	Loc Qty	Loc Code	
MAT	51.972		
112567	0		
114415	3.75		
115045	3.902	6.3734 ft	
115952	40	3.4666 ft	
116623	4.32		
MAT03	1.4583		
112567	1.4583		

J.A 11/03/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

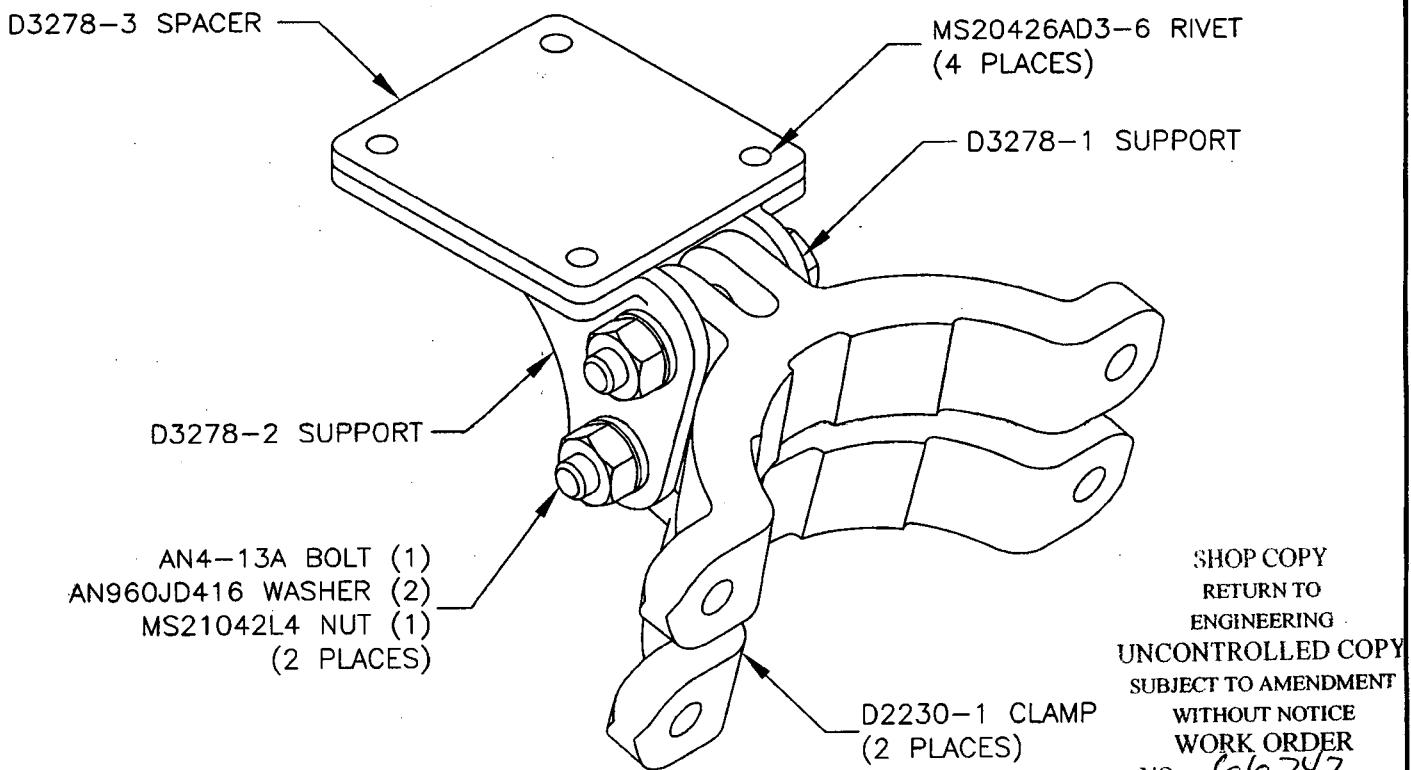
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>B</i>	APPROVED <i>JL</i>	DRAWING NO. D3278
DATE 07.07.24		REV. C SHEET 1 OF 3
		TITLE SUPPORT ASSEMBLY
A	04.03.03	SCALE NTS
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT
C	07.07.24	CHANGED RIVETS PER PAR #185

RELEASED
*07.08.08*D3278-041 SUPPORT ASSEMBLY

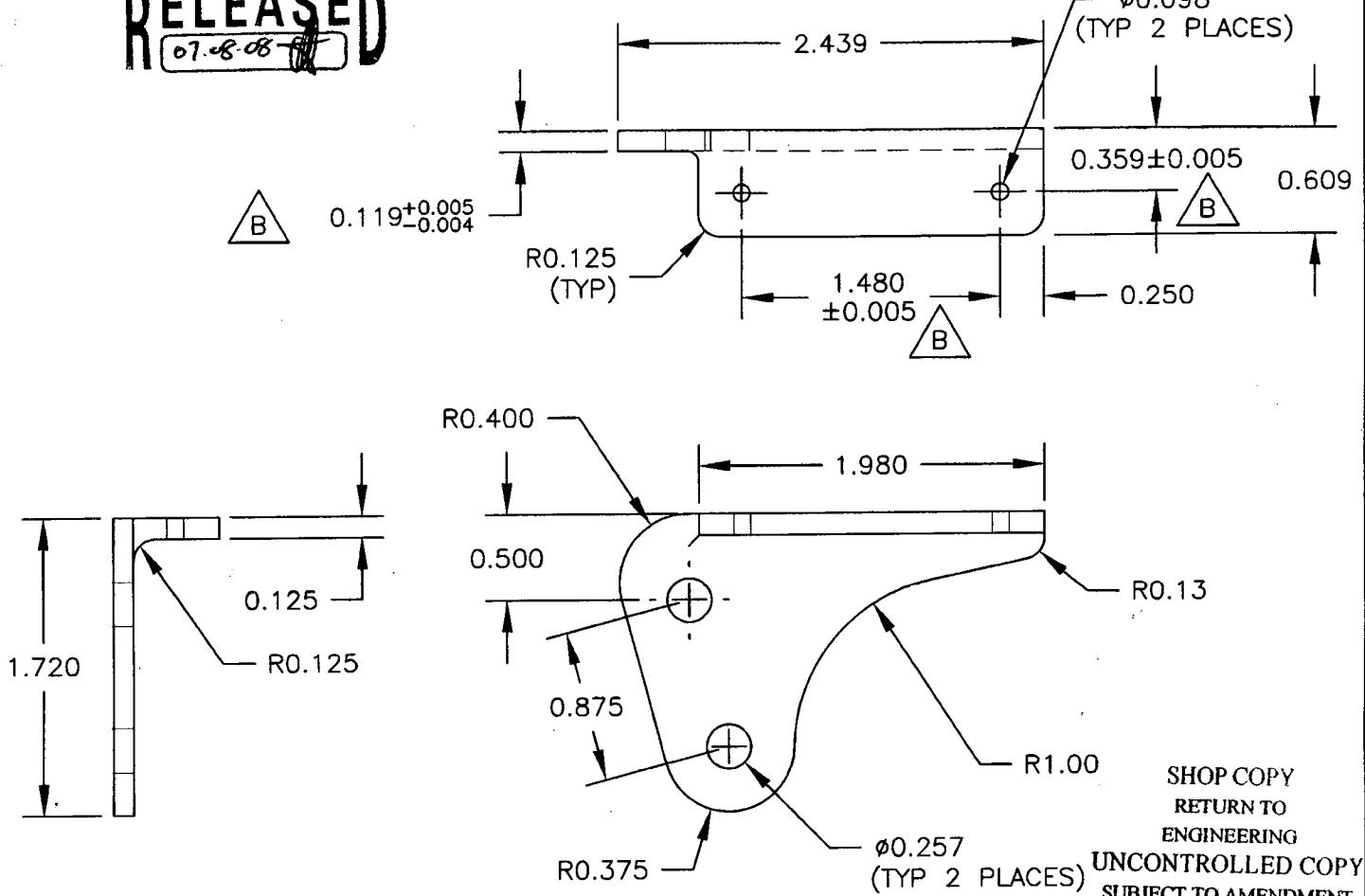
Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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DART

DESIGN <i>QP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C	SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE	1:1

RELEASED
07-08-08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

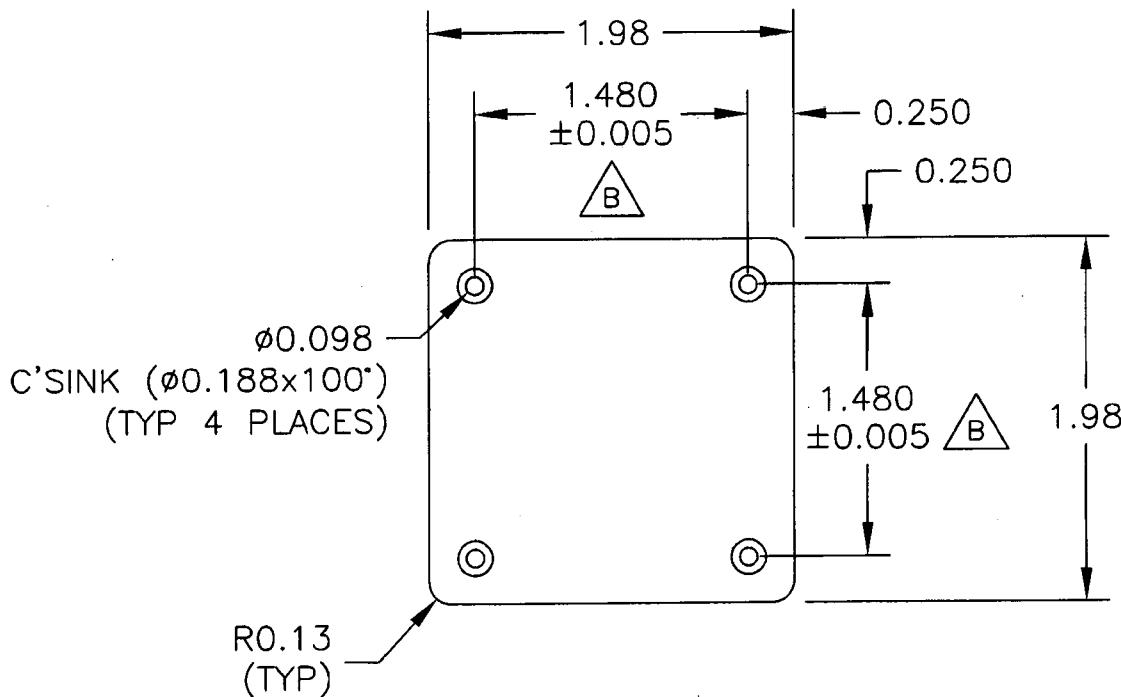
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DART

DESIGN <i>GP</i>	DRAWN BY <i>JL</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>BS</i>	APPROVED <i>HL</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66247

D3278-3 SPACER

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DART AEROSPACE LTD	Work Order:	66247
Description: Support	Part Number:	D3278-1
Inspection Dwg: D3278 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	Ø 0.100	✓		Vern	GA-01
0.359	+/-0.005	0.359	✓		"	"
0.609	+/-0.010	0.611	✓		"	"
0.250	+/-0.010	0.250	—		"	"
1.480	+/-0.005	1.480	—		"	"
R0.125	+/-0.010	R 0.125	✓		R-G	ref.
0.119	+0.005/-0.004	0.120	✓		Vern	GA-01
2.439	+/-0.010	2.440	✓		"	"
1.980	+/-0.010	1.980	✓		"	"
R0.13	+/-0.030	R 0.125	✓		R-G	ref.
Ø0.257	+0.005/-0.000	Ø 0.258	✓		Vern	GA-01
R0.375	+/-0.010	R 0.375	✓		R-G	ref.
0.875	+/-0.010	0.875	✓		Vern	GA-01
0.500	+/-0.010	0.499	✓		"	"
R0.400	+/-0.010	R 0.400	—		R-G	ref.
R1.00	+/-0.030	R 1.000	✓		"	"
1.720	+/-0.010	1.720	✓		Vern	GA-01
R0.125	+/-0.010	R 0.125	—		R-G	ref.
0.125	+/-0.010	0.127	—		Vern	GA-01

Measured by:	A.A	Audited by:	Onf	Prototype Approval:	N/A
Date:	11/03/09	Date:	11/03/10	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	PZ

